[redacted]

Dart Aerospace Ltd.

Date: Thursday, 29/01/2009 9:22:38 AM
User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	**Drawing Name**	: D350-591-115/117A
Job Number	: 45363		
Estimate Number	: 10804		
P.O. Number	:	**Part Number**	: ECN15
This Issue	: 29/01/2009 **S.O. No.** :	**Drawing Number**	: ECN09-513
Prsht Rev.	: NC	**Project Number**	:
First Issue	: / / **Type** : LARGE FAB ASSY	**Drawing Revision**	:
Previous Run	: 00015	**Material**	:
Written By	:	**Due Date**	: 05/02/2009 **Qty:** 9 **Um:** Each
Checked & Approved By	:		
Comment	:		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

REMOVE FROM STOCK:

4 X D350-591-115 B 29077 4x PO

4 ~~5~~ X D350-591-117A B 38295 4x PO

New P/W required

REMOVE FROM EACH KIT PER ECN09-513
4 X AN4-20A BOLTS B 16895x16
RETURN TO STOCK / ADJUST ACCPAC

REPLACE WITH:

4 EACH X AN4-21A B 11695x4
M101390 x28

2.0	AN421A	Bolt

Comment: Qty.: 4.0000 Each(s)/Unit Total : 36.0000 Each(s)
Bolt M101390 09/01/30 (x8)

3.0	QC4	INSPECT 100% KITS FOR COMPLETENESS

09.01.30 (8)

Comment: INSPECT 100% KITS FOR COMPLETENESS

Form: rprocess

Date: Thursday, 29/01/2009 9:22:38 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd. **Drawing Name:** D350-591-115/117A

Job Number: 45363 **Part Number:** ECN15

Job Number:

Seq. #:	Machine Or Operation:	Description :
4.0	PACKAGING 1	PACKAGING RESOURCE #1

117A

Comment: PACKAGING RESOURCE #1

REPACKAGE PER PPP
USING ORIGINAL B/N

Job Completion

09/02/02

Form: rprocess

L Lacelle

From: Kim Johnston [kjohnston@dartaero.com]
Sent: January 29, 2009 9:04 AM
To: 'L Lacelle'
Subject: RE: ECN09-513

AN4-20A ARE REPLACED BY AN4-21A PER REV G OF IIN. Incorporated dsi's are now part of IIN but you can still see them in DSI bluefiles. ECN # has been fixed.

Kim

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: January 29, 2009 7:56 AM
To: 'Kim Johnston'
Cc: 'Mike Petsche'
Subject: ECN09-513

I REC'D ECN09-513, but do not know what bolts have to be changed out, as there is no sheet attached to the ECN. The not says DSI's have been incorporated, but I do not see DSI9494 in the blue files, plus the blue files say under review ECN 09-511 NOT 09-513...can someone please help?

Thank You,
Linda Lacelle
Production Manager
Dart Aerospace Ltd

Date: Thursday, 29/01/2009 9:18:17 AM
User: Linda Lacelle

Bill of Manufacturing

Part Number : D350591117A **Revision** : U/R
Drawing Name : PRE-FLIGHT STEP INSTALLATION **Default Qty.** : 1

Seq#	Item	Description	Qty	U/M	Unit Cost	BOM Cost
1	DC	DOCUMENT CONTROL	0.00	Hours	26.00	0.00
2	PACKAGING 1	PACKAGING RESOURCE #1	0.00	Hours	57.00	0.00
3	D2171	Pick:Packing Kit	2.00	Each	4.40	8.80
4	D2182B	Pick:Packing Kit	0.58	f	0.48	0.28
5	D2274	Pick:Packing Kit	4.00	Each	0.54	2.16
6	D2362041	Pick:Packing Kit	1.00	Each	31.30	31.30
7	D2856400	Pick:Packing Kit	0.63	f	4.24	2.67
8	AN420A	Pick:Packing Kit replace w/ AN4-21A	4.00	Each	0.23	0.95
9	AN960JD416	Pick:Packing Kit	4.00	Each	0.02	0.11
10	MS21042L4	Pick:Packing Kit	4.00	Each	0.09	0.36
11	QC4	INSPECT 100% KITS FOR COMPLETENESS	0.00	Hours	26.00	0.00
12	PACKAGING 1	PACKAGING RESOURCE #1	0.00	Hours	57.00	0.00
13	QC21	FINAL INSPECTION/W/O RELEASE	0.00	Hours	0.00	0.00
			Total BOM Cost			**46.64**

REFERENCE ONLY

Form: RptEstBom

Date: Thursday, 29/01/2009 9:18:14 AM
User: Linda Lacelle

Bill of Manufacturing

Part Number : D350591115 **Revision** : D
Drawing Name : SHORT STEP ASSEMBLY,LO-SKID **Default Qty.** : 1

Seq #	Item	Description	Qty	U/M	Unit Cost	BOM Cost
1	DC	DOCUMENT CONTROL	0.00	Hours	43.00	0.00
2	D2244116	Pick:	1.00	Each	39.68	39.68
3	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	0.00	Hours	90.00	0.00
4	QC5	INSPECT WORK TO CURRENT STEP	0.00	Hours	43.00	0.00
5	D267334	End Cap	2.00	Each	3.40	6.81
6	D2275	Bushing	1.00	Each	6.36	6.36
7	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	0.00	Hours	90.00	0.00
8	QC9	VISUAL WELDING INSPECTION	0.00	Hours	26.00	0.00
9	QC5	INSPECT WORK TO CURRENT STEP	0.00	Hours	43.00	0.00
10	HAND FINISHING1	HAND FINISHING RESOURCE #1	0.00	Hours	37.00	0.00
11	QC3	INSPECT POWDER COAT/CHEMICAL	0.00	Hours	43.00	0.00
12	D26431	Lo Skid Step LH	1.00	Each	5.83	5.83
13	D26432	LO SKID STEP RT	1.00	Each	5.69	5.69
14	MS20600AD4W3	Cherry Rivets	1.00	Each	0.13	0.13
15	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	0.00	Hours	90.00	0.00
16	QC9	VISUAL WELDING INSPECTION	0.00	Hours	26.00	0.00
17	QC5	INSPECT WORK TO CURRENT STEP	0.00	Hours	43.00	0.00
18	HAND FINISHING1	HAND FINISHING RESOURCE #1	0.00	Hours	37.00	0.00
19	POWDER COATING	POWDER COATING	0.00	Hours	90.00	0.00
20	HAND FINISHING1	HAND FINISHING RESOURCE #1	0.00	Hours	37.00	0.00
21	QC3	INSPECT POWDER COAT/CHEMICAL	0.00	Hours	43.00	0.00
22	PACKAGING 1	PACKAGING RESOURCE #1	0.00	Hours	37.00	0.00
23	D2171	Clamp	2.00	Each	5.64	11.29
24	D2182B	Rubber Cushion 3.5" long x2	0.58	f	0.50	0.29
25	D2274	Radius Block	4.00	Each	2.12	8.49
26	D23625	Support Bracket	1.00	Each	15.85	15.85
27	D2856400	Abrasion Strip 7.2" X 1	0.63	f	4.23	2.66
28	~~AN337A~~	~~Bolt~~	2.00	Each	0.42	0.85
29	AN420A	Bolt replace w/ AN4-21A	4.00	Each	0.23	0.95
30	~~AN422A~~	~~Bolt~~	1.00	Each	0.32	0.32
31	AN960JD10	Washer	4.00	Each	0.03	0.14
32	AN960JD416	Washer	6.00	Each	0.03	0.20
33	MS21042L3	Pick:	2.00	Each	0.07	0.15
34	MS21042L4	Pick:	5.00	Each	0.06	0.33
35	QC4	INSPECT 100% KITS FOR COMPLETENESS	0.00	Hours	43.00	0.00
36	PACKAGING 1	PACKAGING RESOURCE #1	0.00	Hours	37.00	0.00
37	QC21	FINAL INSPECTION/W/O RELEASE	0.00	Hours	0.00	0.00
			Total BOM Cost			**106.08**

REFERENCE ONLY

ENGINEERING CHANGE NOTICE

DART AEROSPACE LTD

Date:	09.01.23	Job No.:	00569	ADR Yes/No:	N	ADR Date: 09.01.27	ECN #: 09- 513
Product No.:	D350-591			Created By:	AJS	Approved By:	
Product Name:	HELI ACCESS STEP			Checked By:		General Manager Approval:	

Distribution	Reqd	Resp	Initial / Date
Production Manager	Y	LL	
Production Engineering Coord	Y	EC/DD	
Production Document Control	Y	JLD	
Customer Technical Support	Y	DSTOW	

Distribution	Reqd	Resp	Initial / Date
DQA / QA Coord			
QC Coordinator	Y	JM	
Marketing	Y	SW	
Customer Order Processing			

Reason for Change:

Documents Affected:

IIN-D350-591 REV G

ICA-D350-591 REV 2

PARTS MUST COMPLY [X] **PREVIOUS PARTS SATISFACTORY** [ ]

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	Y	KJ		09.01.27
5	Update Product Compatability Matrix	N			
6	Create Eurocopter Form (FEE)	N			
7	Notify TC / FAA of Change	N			

#	Document Control Actions	Reqd	Resp	Notes	Complete
8	Move Electronic Files	Y	KJ		09.01.27
9	Update Blue/Pink/DSI Folder and Electronic Files	Y	KJ		09.01.27
10	Update Controlled PDF Files	N			
11	Update Master Document List (MDL)	N		(NO MDL)	
12	Update Document Record (DR)	Y	KJ		
13	Update Product Development Summary	N			
14	Update QSI 021 and/or STC Approval List	N			
15	Update Parts / STC Database	N			
16	Update / Verify ARC Database	N			
17	Create / Update Change Record Form	N			
18	Create / Update PPP's	N			
19	Update Document Control Database / Laminated Dwgs	N			
20	Update Grey Project Binder	Y	KJ		09.01.27
21	Update D-Part/M-Drawing/DSI/DEO Master Binders	N			
22					
23					

Description / Action:

RELEASE IIN-D350-591 REV G & ICA D350-591 REV 2

ALL KITS IN STOCK MUST COMPLY, CHANGE IS: BOLTS FOR FASTENERS FOR -115 & -117A UPDATED PER PAR 08-031

NOTE DSI'S 9494, 9340, 9333 & 9410 HAVE BEEN INCORPORATED

09.01.30

4XD350-591-115 B29071

4XD350-591-117A B38295

ECN Verified & Complete: _____ Date: _____

Preventive Action Report

PAR 08.031

Raised by: Jason Murdock | **Source:** Special Projects / Trial Fitting | **Sheet No.** 1 of 1

Issue for Dept./Supplier: Engineering - Design | **Date:** 08/09/08

Product/Service: D350-591-117A steps (Pre-flight) | **Priority:** HIGH / LOW

Area of Standard:
QSI
QSP
QSPM

Documents:
P/O
Invoice
W/O
Batch No.
TSR
Drawing

Section A
Description of Issue Upon a trial fit, of the step, it was found that the original bolts (AN4-20A) are too short, and that the AN4-21A bolts, suit the assembly more.

Forward to Director, Quality Assurance on completion of this box

DQA: Section B: Indicate who is responsible for creating P/A, and a completion date. Section C: Indicate who will verify completion of P/A.

Section B
Preventive Action Responsible for Investigation/PA: M. Petsche To be done by: 08/10/30

No	Initial	Action Description	Responsible	Due date	Sign/Date
1.	JM.	Place the Dwg / W/O / and parts list under Review to implement the new bolt length.	L.L. / M.P.	08/09/12. / 08/10/30	
2.	SW	Quarantine stock (FG011A) Qty 4 B38295 @ CHG002	Jason M.	08.09.16	08.08.16
3.	SW	Change bolts per updated w/o.	~~L.Lucelle~~ Jason M.		
4	AJS	SEE REVG OF LIN (Attached)	AJS		AJS 09.01.23

Fault Category:

Section C
Verification of P/A Responsible for Verification of PA:

No	Verification Method	Sign	Date

Forward to DQA on Completion of Verification

DQA: _____

Date: _____

QA Purposes only P/A Closed _____ Date _____